Work Orde September-13-12	•			Page 1										
tem ID: Revision ID: tem Name:	D412-702-31 Harness Assem			Accept	*N900040100* Setup							*NS1* *NS2*		
Start Date: Required Date: Reference:	9/07/12 10/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:									
Approvals:	Process Pla	n: MLD	Date: 12-09-17	Tooling:		Date:				Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):		Date:					Stop	*N	R2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool	ID Too	ol#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	<del></del>
Draw Nbr	Revi	ision Nbr												
ICAD412-702	REV	74											/	. /
00	<del>. <u> </u></del>			0.00									5/	-/ /
*100* Small Fab		Memo		0.00					K				p)id	10/23
Small Fab		Assemble a	s per dwg ICA D412-702 p.	49										,
110		QC5- Inspect part comp	leteness to step on W/O	0.00					Ţ					
*110* QC Quality Control		Memo		61 00.0	10.33 B									
20				0.00										
*120* Packaging		Memo		0.00							al court and the day			
Packaging		Identify wit CHG001	th P/N & CHG# and pack for		D412-702-313				1		+		lä	<sup>Q</sup> X14/23/B

		DQA:	Date:	
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closed.	Date.				
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No.					Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other			
NCR No.					Work Order Update		Large Fab	Composite		Supplier				
Root				Descri	ption of work order update	Initial	Act	tion	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector			
Doc/Data														
Equip/Tooling			:											
Operator														
Material														
Setup														
Other														
Process			· .			ĺ								
Supplier .	_													
Training	_								İ					
Unapproved		<u> </u>	<u> </u>			ALUT CAT	CORV		<u> </u>	<u></u>	1			
						AULT CAT	EGURY		-					
Landir	ng Gear			_	General Bend	Grain			Ovalized		Pressure/Forced			
}	Bending Centre N	-t C		o/s	BOM/Route	Hardw	aro	<u> </u>	Over/Under	tolerance	Temperature/Cure			
,	Cracks	ot Conce	itric to	<sup>0/3</sup>  -	Broken/Damaged	$\vdash$	tion Incomplete	-	Part Incorre	<del> </del>	Weld			
}	Crushed/	Crimped		-	Burrs	⊢ :	ctions Incomplete/	Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled			
}	Cuffs	Crimpeu		-	Contamination	$\vdash$	enance		Part Moved		7			
ŀ	Heat Trea	at			Countersink	Mislat			Positioned \					
	Inspectio		Tube		Cut Too Short	Misre			Power Loss/		Other			
	Ripples in			<u> </u>	Drill Holes	Offset		<u> </u>	J,	_				
	Torque V		Extrusio	n H	Drawing	1	Calibration							
}	Turning S				Finish		Sequence							
	Wave/Tw				Folio	Outsic	le Dimensions							

Work Orde			*90126*									Page 2
Item ID: Revision ID: Item Name:	D412-702-			Accept	*N900	)*	Setup	Start Stop	1 4	S1* S2*		
Start Date: Required Date: Reference:	9/07/12 10/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):	Da		Run	Start Stop	*N *N	R1* R2*		
Sequence ID/ Work Center II  130 *130* QC Quality Control	D	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Re Qt	-	Reject Number	Insp. Stamp

\$12-10-24

										DQA:	Date	à:
NCR: Y	es / No				WORK ORDER NON-C	CON	FORN	/IANCE / UPD/	ATE			
										QA Closed:	Date	;:
					DISPOSITION	ļ			AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er:		•		Rework	7 <b> </b>		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap	<b>┤                                    </b>		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
10111	···.				Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR N	No.				Work Order Update	┪ ┃		~ <b>—</b>	Composite		Supplier	7   7
	•				· <b>L</b>			- <u>L</u>				
Root				Descri	iption of work order update	Ini	itial	Actio	n	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	nief Eng Description		Date	Verification	QC Inspector	
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Supplier												
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					F	AULT	CATE	GORY				
Landi	ng Gear			_	General				<b>,</b>	<del>-</del> 1		
	Bending				Bend		Grain			Ovalized	ļ	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Ш	lardwa	re		Over/Under	tolerance	Temperature/Cure
•	Cracks				Broken/Damaged		nspecti	ion Incomplete	<u> </u>	Part Incorrect		Weld
					Burrs		Instructions Incomplete/Unclear			Part Lost/M	issing	Wrong Stock Pulled

Mislabeled Positioned Wrong Heat Treat Countersink Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Ripples in Bend Drill Holes Offset Drawing Out of Calibration Torque Waves in Extrusion Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

Maintenance

Contamination

Part Moved

Cuffs

**Picklist Print** Page 1 September-13-12 1:42:13 PM 90126 Work Order ID: Parent Item: D412-702-313 Required Date: 10/05/12 **Start Date: 9/07/12** Parent Item Name: Harness Assembly Start Qty: 1.00 Required Qty: 1.00 Comments: IPP Rev:A new issue DD 10.04.30 verified:EC Qty per Kit Total Component Item ID/ Replacement Mfg/ Last Unit of Qty on Status Date Bin **Primary** Route Qty Item Name Measure Item ID Location Location Seq ID Hand Tssued Purch Item Qty Issued/ D3570-2 No 100 Each 3.0000 Manufactured Bracket Location Loc Qty Loc Code GA 3 80479 3 D4088-043 100 Manufactured No Each 13.0000 Shoulder Harness Location Loc Qty Loc Code ST268A 13 87352 13 MS24694-S50 100 Purchased No Each 57.0000 Screw Location Loc Qty Loc Code ST289 13 116900 118078 119124 11

> 43 43

> > Each

0.0000

100

AN960JD10L Washer

Purchased

NAS1149D0332J

ST289A

ST305

No

121166

122441

										DQA:	Date:		
NCR: Y	es / No	)			WORK ORDER NON-	CON	FORM	ANCE / UPDATE					
										QA Closed:	Date:		
Work Orde	nr.				DISPOSITION			AGAINS	T DE	PARTMENT/	PROCESS		
Work Orde	=1.				Rework	7		Skid-tube Crosstub	و		Water Jet	Engineering	
Part No.					Scrap	1		Machining Small Fa	ļ	Prod	d. Eng. Coor.	Quality	
raitino.					Use-as-is	1 1		noforming Finishin	<del></del>	ŧ	e/Packaging	Other	
NCR N	No		•		Work Order Update	]		Large Fab Composit	-		Supplier		
Root				Descri	ption of work order update	ir	nitial	Action		Sign &		T .	
Cause	Date	Step	Qty		or Non-conformance	1	ef Eng	Description		Date	Verification	QC Inspector	
Doc/Data							<u> </u>						
Equip/Tooling													
Operator						İ		,					
Material													
Setup													
Other								'					
Process			•								in		
Supplier													
Training	Ш .												
Unapproved						1				<u> </u>		<u> </u>	
						AUL	T CATE	GORY			<del></del>		
Landi	ng Gear			_	General ¬	$\overline{}$				7	_	<b>.</b>	
	Bendir	_		<u> </u>	Bend	-	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced	
	$\vdash$	Not Conce	entric to (	o/s	BOM/Route		Hardwa		$\perp$	Over/Under	<del> </del>	Temperature/Cure	
Cracks Broken/Damaged						$\vdash$		on Incomplete	$\vdash$	Part Incorre	-	Weld	
	—	d/Crimped	l	<u> </u> _	Burrs	$\vdash$		ions Incomplete/Unclear	<u></u>	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs		*	L	Contamination	$\vdash$	Mainte		$\vdash$	Part Moved			
ì	Heat Treat     Countersink							eled		Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-13-12 1:42:13 PM

Work Order ID:

90126

Parent Item:

D412-702-313

Parent Item Name:

Harness Assembly

MS21042L3

Nut

Purchased

No

**Start Date:** 9/07/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

100 Each 2,768.0000 4

Location Loc Qty Loc Code

<b>Location</b>	Loc Qty	<u>L</u> c
316	719	
122452	719	
ST300	581	
117885	32	
119017	411	
119075	138	
ST317	1468	
122141	1468	

4

										DQA:	Date:	
NCR: Yes / No						WORK ORDER NON-CONFORMANCE / UPDATE					Date:	
Work Order:						DISPOSITION	DISPOSITION AGAINST DEPA					
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Dat	e   9	Step	Qty	•	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup					I							
Other												
Process												
Supplier	- 1											

**FAULT CATEGORY Landing Gear** General Grain Ovalized Pressure/Forced Bend Bending Temperature/Cure BOM/Route Over/Under tolerance Hardware Centre Not Concentric to O/S Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped. Cuffs Contamination Maintenance Part Moved Mislabeled Positioned Wrong Heat Treat Countersink Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

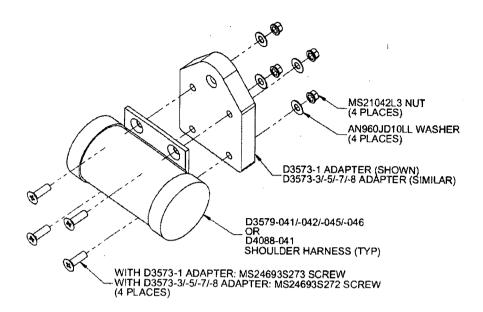
**Outside Dimensions** 

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

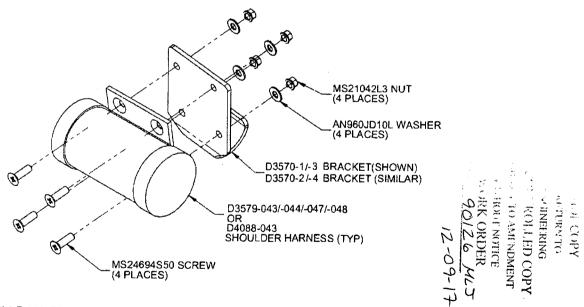
Wave/Twist in Tube

Folio

Training Unapproved



<u>DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND</u> <u>D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B OR -301/-303/-305/-307/-309/-315/-317 HARNESS ASSEMBLIES</u>



DETAIL 'L' D412-702-111A/-111B/-113A/-113B OR -311/-313/-321/-323 HARNESS ASSEMBLIES

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